

Work Order ID 72498

Wednesday, July 27, 2011 9:01:56 AM



Page 1

Item ID: D4034-5

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 7/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4034 | B |

| | | |
|-----|--|------|
| 100 | | 0.00 |
|-----|--|------|



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4034
2- Drill hole as per dwg using DT9561

[Signature] 11.07.29 (6)

| | | |
|-----|------------------------------------|------|
| 110 | QC6- Inspect dimensions to drawing | 0.00 |
|-----|------------------------------------|------|



QC

Memo

0.00

Quality Control

8/10/02

(x6)

| | | |
|-----|---|------|
| 120 | Identify as per dwg & Stock Location: WAS | 0.00 |
|-----|---|------|



Packaging

Memo

0.00

Packaging

[Signature] 11.07.29 (6)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 72498

Wednesday, July 27, 2011 9:01:56 AM



Page 2

Item ID: D4034-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 7/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/02

11-0812
(6)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 27, 2011 9:02:02 AM

Page 1

Work Order ID: 72498



Parent Item: D4034-5



Parent Item Name: Rib

Start Date: 7/27/2011

Required Date: 8/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC IPP Rev:D 11.01.19 AS PER DWG
REV.B DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-------------------|---------------|----------------|--------|
| M304TS0.750W.049 | | Purchased | No | | | 100 | f | 274.0114 | 1.4375 | 6.052632 + 286 | | 11.07.29 | |
| 304 SQ Tube .75x.75x.049W | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT018

102.798609

117690

4.372109

117775

98.4265

MAT034

2.0639

117337

2.0639

WA

169.14894

118184

169.14894

8.86

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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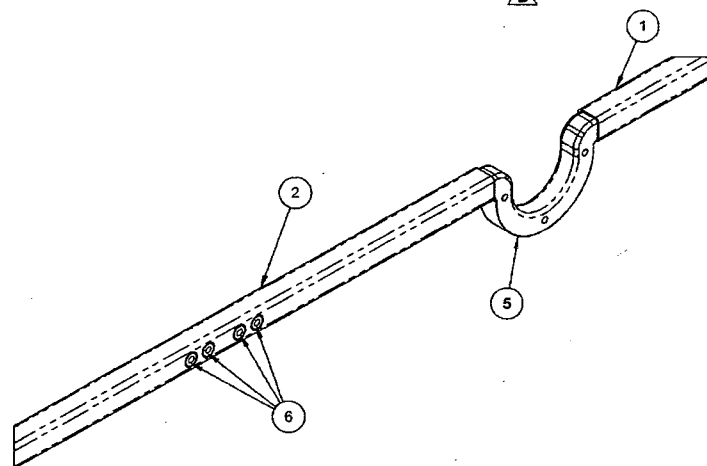
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

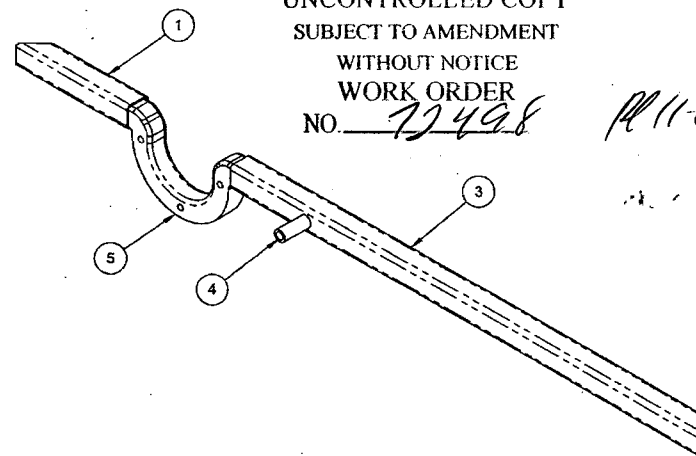
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NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 4 | | D4021-9 | BUSHING |



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72498 11-07-27

RELEASED
R 2011-01-18
MB

| | | | |
|------------|---------------------------------------|--|--------------|
| B | ADDITIONAL HOLES ADDED ON D4034-3 RIB | SC | 10.12.20 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | B | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4034 | SHEET 1 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | UPPER RIB ASSY, BASKET BASE | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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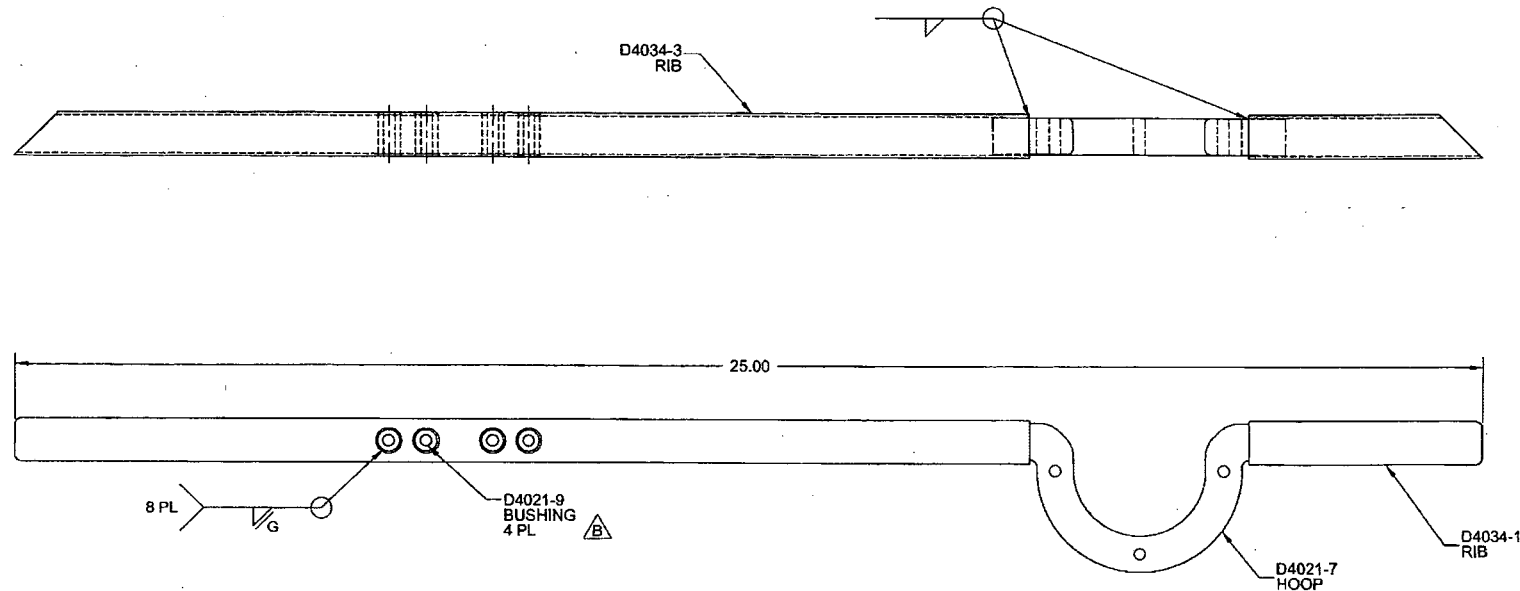
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

12498



D4034-041 AFT UPPER RIB ASSY

RELEASED
2011-01-38

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | B | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | UPPER RIB ASSY, BASKET BASE | NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

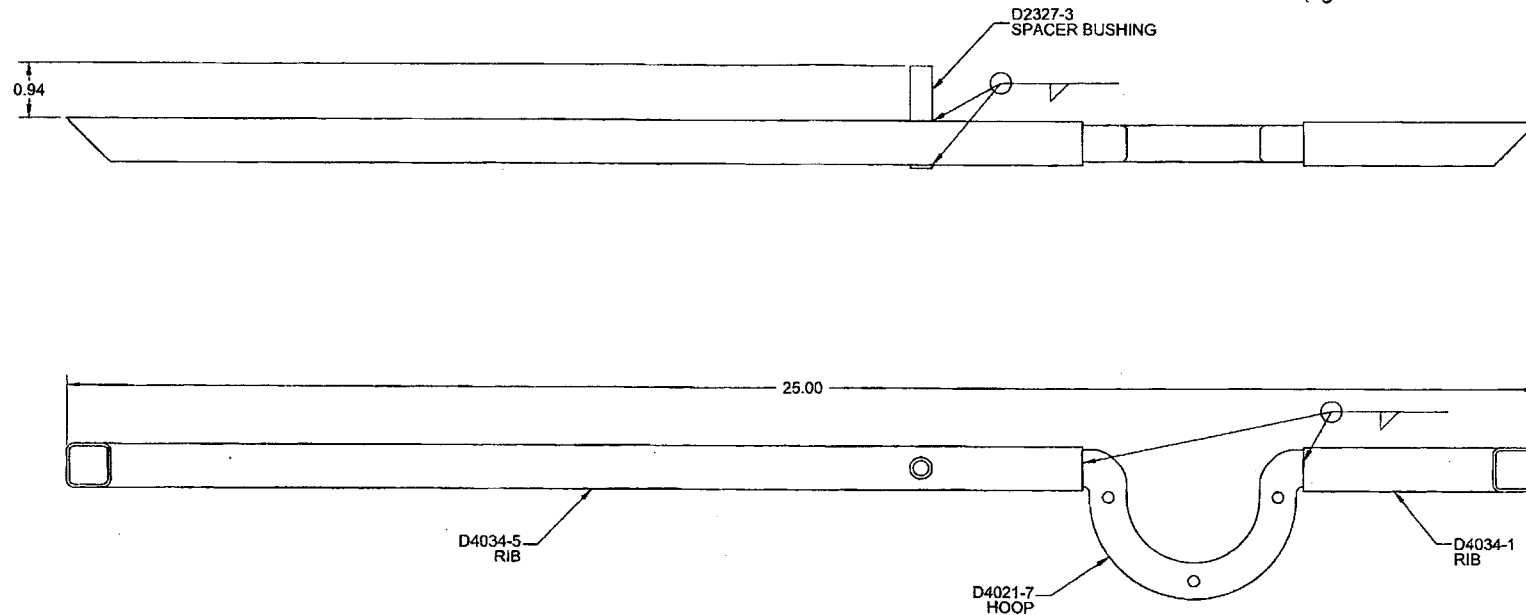
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



12496



D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JS | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4034 | SHEET 3 OF 4 |
| APPROVED |  | TITLE | SCALE |
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8 7 6 5 4 3 2 1

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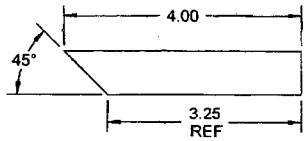
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

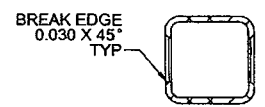
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NOTE: Date & initial all entries

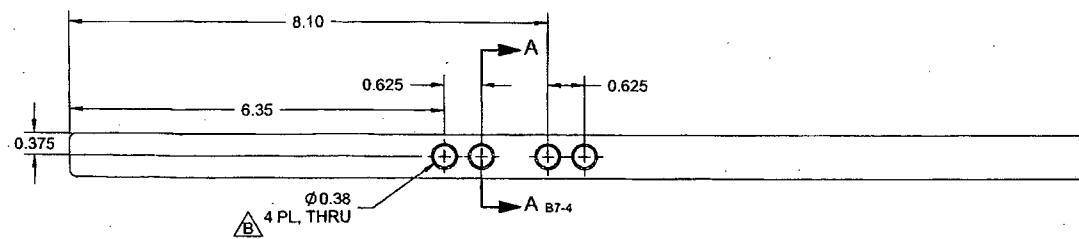
72498



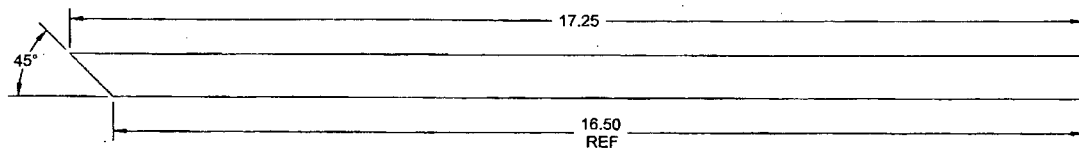
D4034-1 RIB



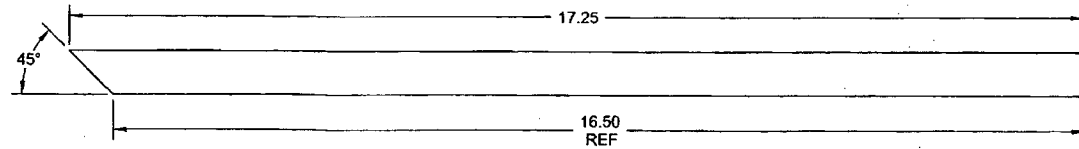
SECTION A-A D4-4



D4034-3 RIB







D4034-5 RIB



RELEASED
2011-01-10

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

| | | | |
|---|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4034 | SHEET 4 OF 4 |
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